

Date: Thursday, 14/05/2009 11:13:14 AM  
 User: Melanie Fautoux

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 47961  
 Estimate Number : 10707  
 P.O. Number :  
 This Issue : 14/05/2009 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 1/1 Type : SMALL / MED FAB  
 Previous Run : 47665  
 Drawing Name : ARM  
 Part Number : D2012105  
 Drawing Number : D2012-105 U/R  
 Project Number : N/A  
 Drawing Revision : D1  
 Material :  
 Due Date : 21/05/2009 Qty: 2 Um: Each  
 Written By :  
 Checked & Approved By : MF 09-05-14  
 Comment : Est Rev: 02.04.03 Added Inspect level 3 NG

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0500W035 304 RD Tube .500 x .035W



Comment: Qty.: 2.7567 f(s)/Unit Total: 27.5667 f(s) 5.5134  
 Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)  
 Identify as D2012-101  
 Batch: 17111704 FF 09-05-14

2.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Punch to length as per Dwg D2012-105 & template D2012-105T1

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 7:40


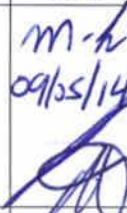


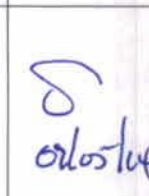
OVEN TEMPERATURE: 320°

um20 09/05/15

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2012-105 PAR #: N/A Fault Category: Prod/FAB Assy mat small NCR: (Yes) No DQA: D Date: 09/05/20  
 Resolution: SCRAP Disposition: Scrap QA: N/C Closed: D Date: 09/05/20

NCR: <u>47961</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/5/14	# 3.0	two struts Bent with wrong angle RL human error		Scrap And Destroy And Replne Qty @ M <u>111704</u>	M-h 09/05/14 	S 09/05/14 		S 09/05/14 

NOTE: Date & initial all entries

## Process Sheet

Order: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 47961

Part Number: D2012105

Job Number:



Seq. #:

Machine Or Operation:

Description :

FINISH TIME:

8:10

cmd 09/05/15

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(2)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

bx 09-05-15

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST 229

JS 09/05/15 (X2)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/15 JF

Comment: FINAL INSPECTION/W/O RELEASE

WLF 09-05-15

Job Completion



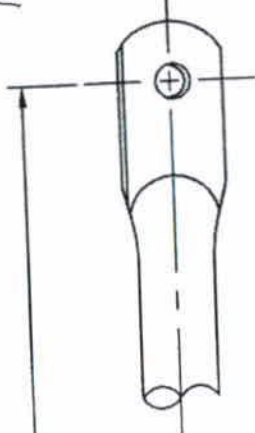
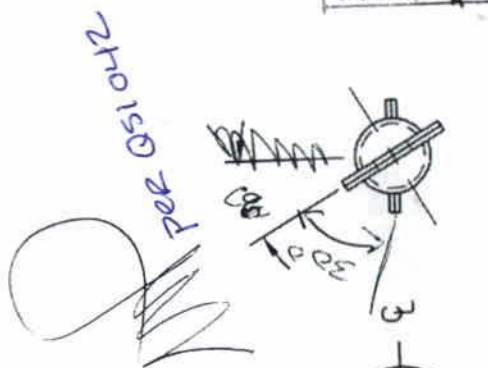


# DART



DESIGN <i>[Signature]</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2012-105	REV. D SHEET 1 OF 1
DATE 98.04.28		TITLE ARM	SCALE NTS
A	92.06.04	NEW ISSUE - DRAWN FROM D2012	
B	96.06.25	30° ANGLE ROTATED 60° CCW	
C	97.09.03	CORRECTED VIEWS PER TSR A374	
D	98.04.28	ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD	
D1	<del>98.03.25</del>	ADD FINISH	

RELEASED  
98/05/05 KE



31.06

PUNCH BOTH ENDS PER SPEC  
CONTROL DRAWING D2727

31.86 Total Length  
31 7/8

#47961

NOTES:  
1. MAKE PER TEMPLATE DT8116 (WAS D2012-105)  
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.500 x 0.035 WALL  
3. FINISH: POWDER COAT BLACK SANDTEX (4.35 F) PER DART Q51 005 4.3